

MI 385

Gazaltı (MIG/MAG) Kaynak Teli - Stainless Steels

Standards

AWS/ASME SFA - 5.9	ER 385
EN ISO 14343 - A	G 20 25 5 Cu L
TS EN ISO 14343 - A	G 20 25 5 Cu L
DIN M. No.	~1.4519

Materials

Width	Material
X2CrNiMoN17-13-5	1.4439
X1CrNiMoCuN25-25-5	1.4537
X1NiCrMoCu25-20-5	1.4539

Properties and Applications

Fully-austenitic stainless steel wire electrode for GMA (MIG/MAG) welding of unstabilized or stabilized corrosion resisting Cr-Ni-Mo alloyed stainless steels like 904L/1.4539. Especially used in flue gas desulphurization plants, fertilizer plants, sea water transfer fittings, petrochemical, paper and pulp industries, etc. Due to high Ni, Mo and low C content, weld metal has high resistant to intergranular, pitting, crevice and stress corrosion types in chloride containing solutions, phosphorus-, sulphur-, acetic-, formic acids, sea water. Stick Electrode : EI 385TIG Welding Rod: TI 385

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni	Mo	Cu
Welding Wire	0.01	0.40	1.80	20.00	25.00	4.25	1.50

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	M12	380	550	39	20°C → 90	-196°C → 60

* Chemical composition and mechanical properties are valid when using shielding gas .

Application Information

Welding Positions

PA PB PC PD PE PF PG

Polarity:

Protection Gas:
M13 M12 M14 I1

Welding Parameters & Efficiency

Diameter (mm)
1.20

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
23009EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.